

Work Order ID 62957

Thursday, October 14, 2010 12:38:33 PM



Page 1

Item ID: D3417-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	F								

100

0.00



Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA954

Folio Rev:

Dwg D3417 Rev:

2-Deburr

10.11.5 20

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10.11.5 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62957

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Page 2

Item ID: D3417-9

Accept

Revision ID:

Item Name: Washer

Start Date: 10/14/2010 Start Qty: 20.00

Required Date: 10/18/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 53

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup

Start

Stop



Run

Start

Stop



20

0

10/11/08

10/11/08

MF

10-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, October 14, 2010 12:38:36 PM

Page 1

Work Order ID: 62957

Parent Item: D3417-9

Parent Item Name: Washer




Start Date: 10/14/2010

Required Date: 10/18/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 10-08-03 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500  DELRIN ROUND BAR 1.25"		Purchased	No				f	32.1500	0.0296	0.623158		10.11.5	

Location

Loc Qty

Loc Code

MAT

32.15

114586

19.3

114733

12.85

666

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

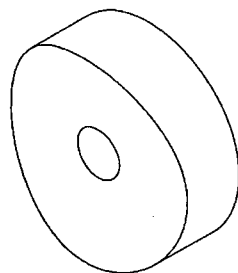
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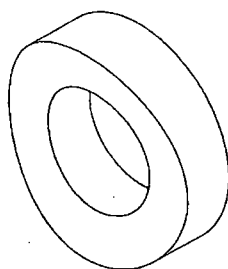
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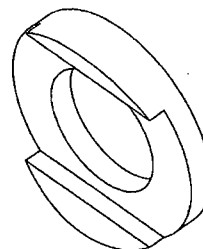
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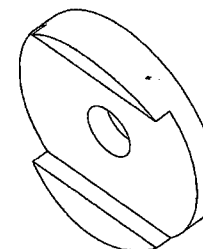
D3417-1 WASHER



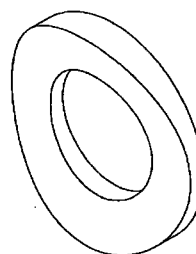
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

SHOP COPY
 REVISION
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO CHANGE
 WITHOUT NOTICE
 WORK ORDER
 NO. 42957

RELEASED
 2010-09-15

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
 REF DART SPEC M-DELRIN-R
 OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
 REF DART SPEC M-DELRIN-B
 OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
 REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
 D3417-3, 0.010 lbs
 D3417-5, 0.010 lbs
 D3417-7, 0.010 lbs
 D3417-9, 0.004 lbs

REV.	DESCRIPTION	BY	DATE
F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

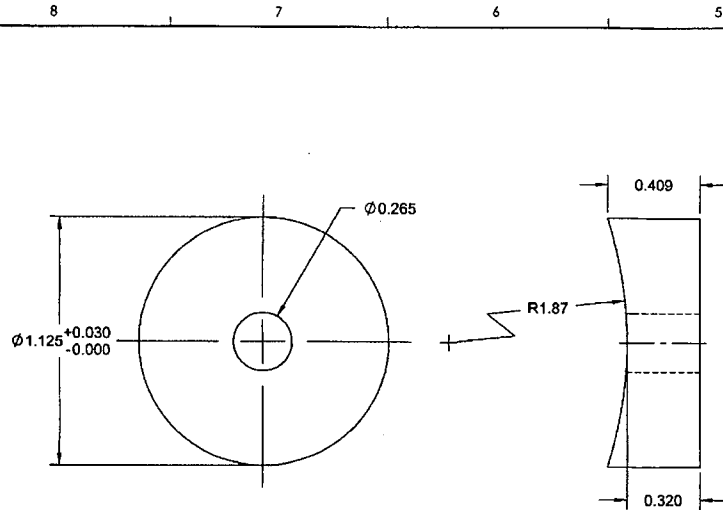
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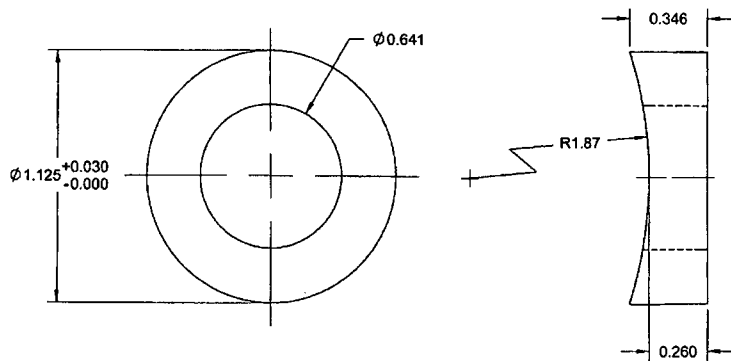
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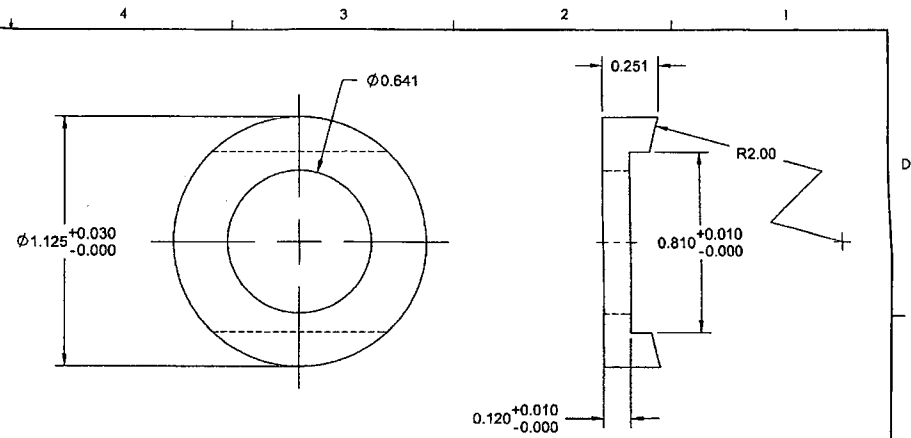
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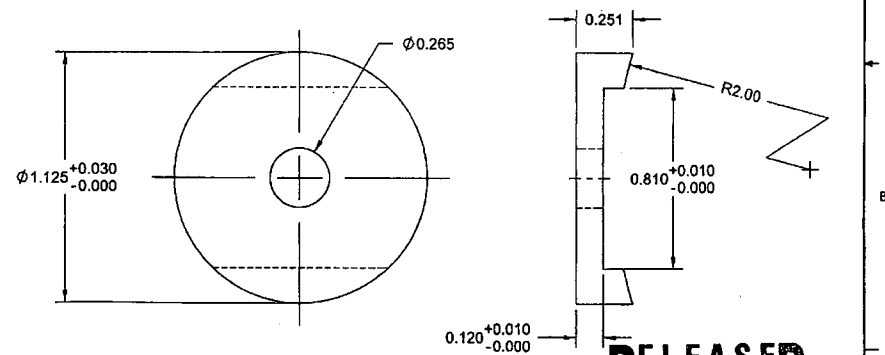
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

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2010-09-15

w/o 62957

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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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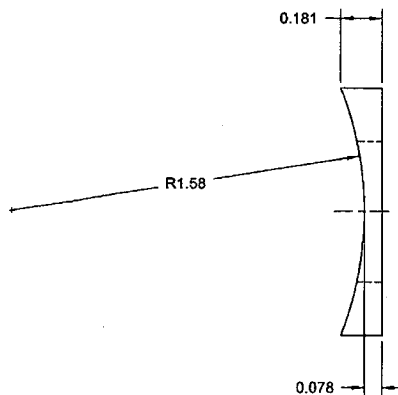
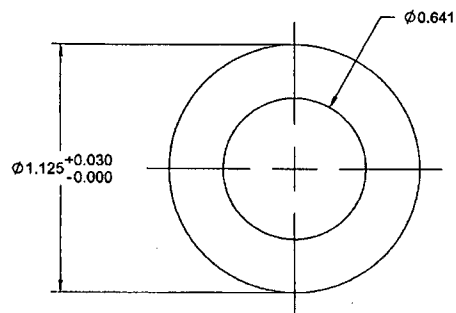
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D3417-9 WASHER



w/o 62957

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2010-09-15
MD

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3417	REV. F
MFG. APPR.	<i>[Signature]</i>	TITLE WASHER	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	10.07.26		

Dart Aerospace Ltd

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